

Date: Friday, 01/08/2008 10:42:26 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	: 40892			Part Number	: D22303		
Estimate Number	: 10256			Drawing Number	: D2230 REV F		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/08/2008	S.O. No.	:	Drawing Revision	: F		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 15/08/2008		
Previous Run	: 40341			Qty:	200	Um:	Each
Written By	:			Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		
Checked & Approved By	: JUL 08. 8.05						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
		 <b>Comment:</b> Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Batch: B33310
2.0	BAND SAW	BAND SAW
		 <b>Comment:</b> Band Saw <del>Cut D2423 extrusion to 0.82"</del> Cut @ meter Batch:
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 <b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 <del>Machine per folio D2230-3</del> <del>Check for crack while loading into the machine.</del> <del>D2230 REV F</del> <del>18/08/08/25 x200</del>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <del>Rec'd + inspect for trans. damage</del> <del>as per drawing</del> <del>10/08/08/25 200</del>
5.0	QC8	SECOND CHECK
		 <b>Comment:</b> SECOND CHECK <del>5</del> <del>10/08/08/10 x200</del>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 40892		Part Number: D22303
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 <i>also S 08/09/11</i>
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble and deburr rough edges after tumbling		
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  <i>200X</i>
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>m-f 08/09/11</i>
8.0	QC5 	INSPECT WORK TO CURRENT STEP  <i>S 08/09/11 x82</i>
Comment: INSPECT WORK TO CURRENT STEP		
9.0	POWDER COATING 	POWDER COATING <i>M 108523</i>
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		
START TIME:	9:00 AM	
OVEN TEMPERATURE:	320°F	
FINISH TIME:	9:30 AM	
10.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>9/08-07-12 x200</i>
Comment: INSPECT POWDER COAT/INSPECT POWDER COAT		<i>m-f 08/09/12</i>
11.0	PACKAGING 1 	PACKAGING RESOURCE #1  <i>200X</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST476		
12.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>1808/09/15 x200</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>mf 08-09-15</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40812
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230	Rev: F	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	

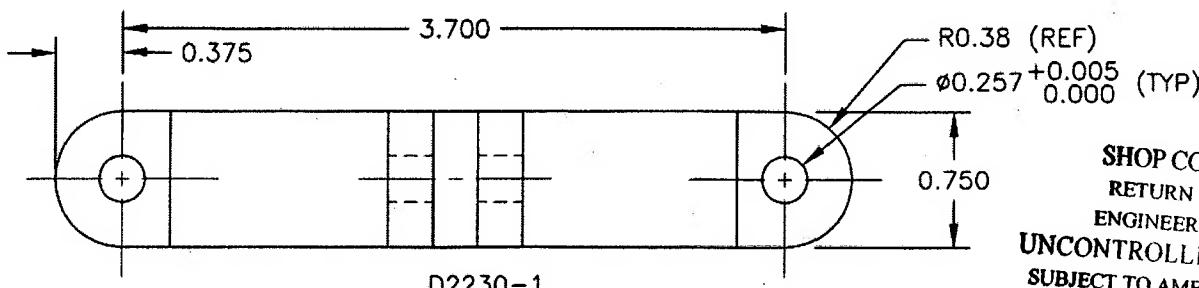
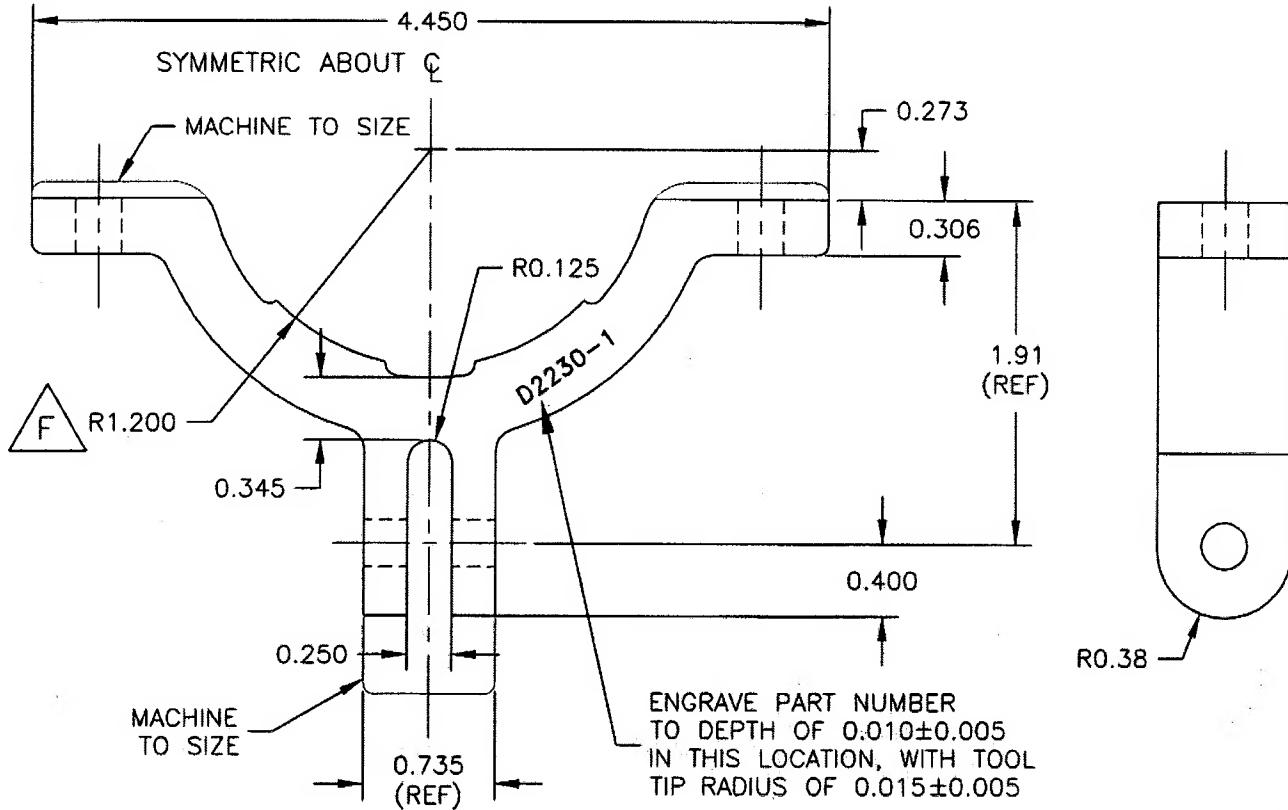
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	[Signature]

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
		REV. F
DATE		SHEET 1 OF 2
99.12.13		SCALE
		1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

**RELEASED**

99.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

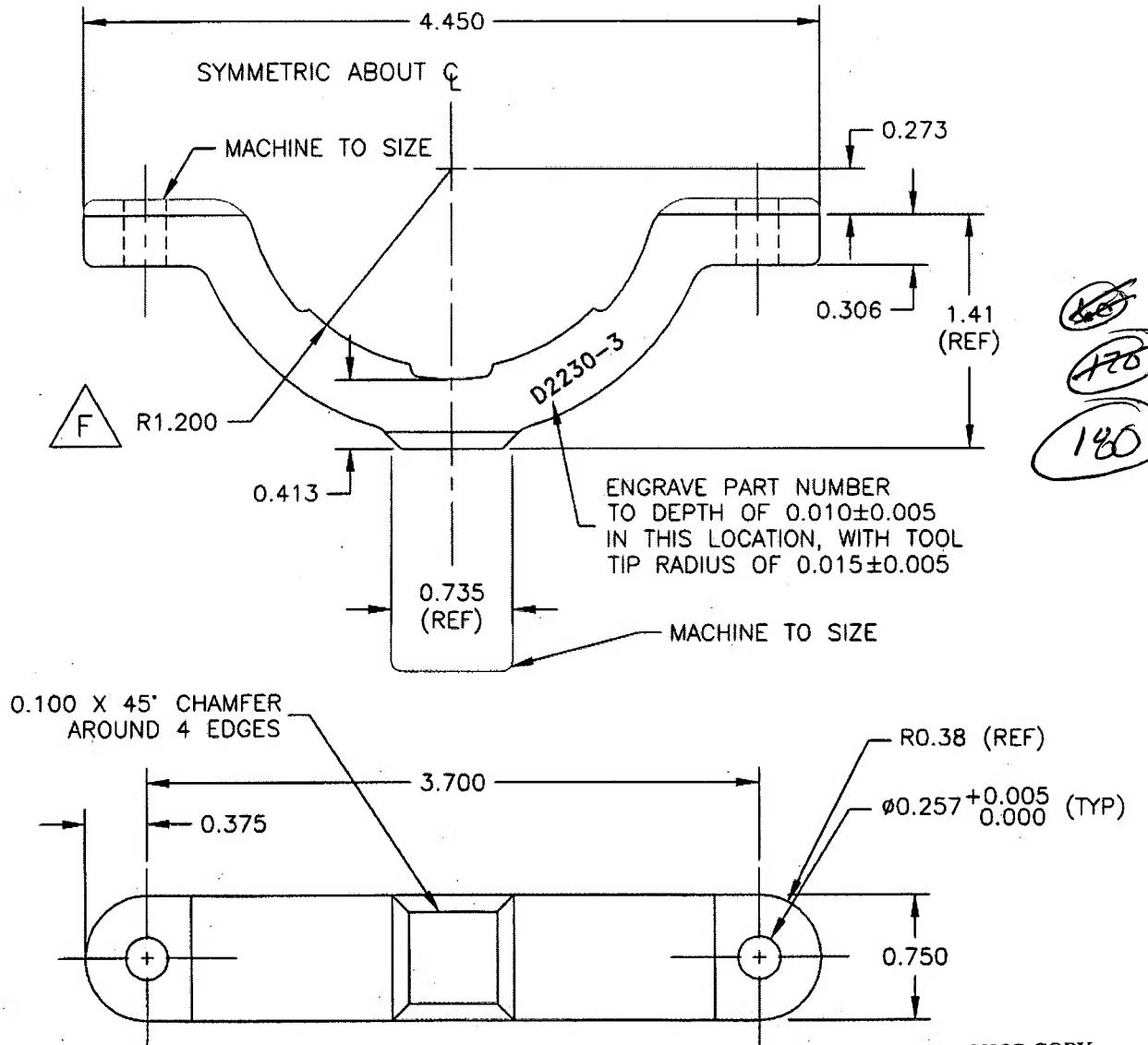
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40893

**DART**

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE 99.12.13		REV. F SHEET 2 OF 2 TITLE MOUNTING LUG SCALE 1:1

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
 BREAK ALL EDGES 0.000-0.015  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 40892



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug B40892	6881

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig Walz".

Vankleek Hill, September 8, 2008